

Date: Monday, 6/5/2006 7:47:18 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET ASSEMBLY
<b>Job Number</b> : 27367	
<b>Estimate Number</b> : 10703	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3121041
<b>This Issue</b> : 6/5/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3121 REV C2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C2
<b>Previous Run</b> : 24677	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 6/30/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>[Signature] 06.06.05</u>	
<b>Comment</b> : Est Rev. Pick: A 04.02.18 New issue KJ/DS	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M174B1000X02000	17-4 SS Bar
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**Comment:** Qty.: 0.2840 f(s)/Unit Total: 1.1361 f(s)  
 Material: 17-4 SS Bar per AMS 5604/5643  
 (M17-4-B1.000x02.000)  
 Identify for D3121-111  
 Batch: M19478

JL 06/07/22

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blanks: (1.000" x 2.000") 3.250" long

JL 06/07/22

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-11 as per Folio FA331 and Dwg D3121 Identify as D3121-11

2-Deburr

3-Scribe batch number

JL 06/07/22

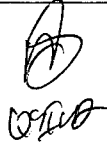
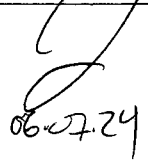

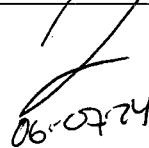
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JL 06/07/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/22	3	- 1 part scrapped dimension .392 $\pm .002$ is .389 - bearing is too loose		Scrap / destroy and Repeel	JL 06/07/22	 06-07-24	 06-07-24	 06-07-24

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/09/11

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:47:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27367

Part Number: D3121041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/22 x4

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt B27412

J.G 06/09/10 4

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

B27433

J.G 06/09/10 4

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

J.G 06/09/10 4

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SC 06-09-10 4

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57409

06/9/11 (4)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/11 (4)

Job Completion



W 06/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

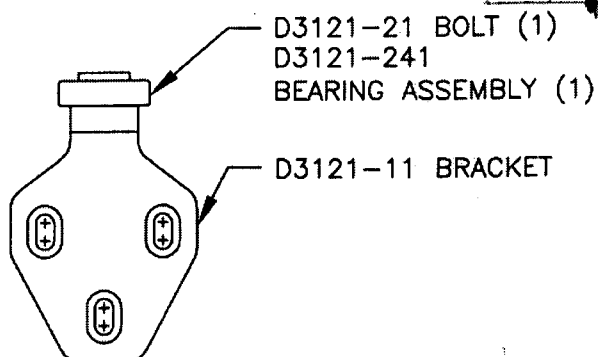
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 1 OF 10
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
C1	04.03.26	3.97 WAS 4.00; 6.11 WAS 6.14	
C2	04.04.26	0.230 WAS 0.238	

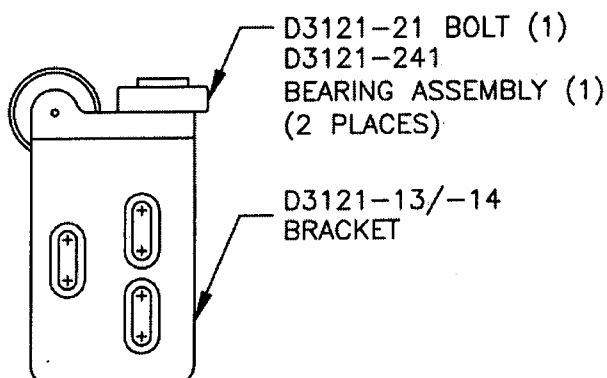
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04-03-01



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)

**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)

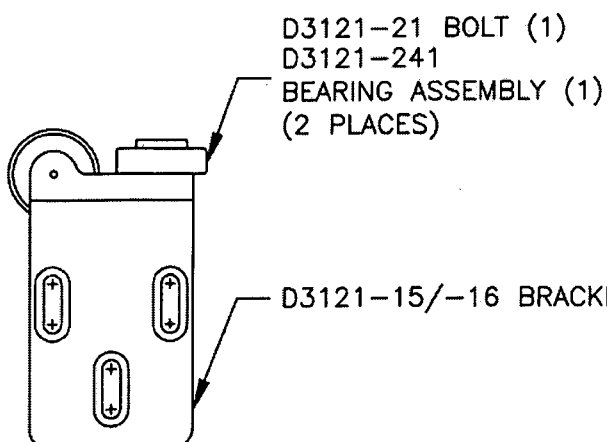
D3121-11 BRACKET



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)

D3121-13/-14  
BRACKET



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

D3121-15/-16 BRACKET

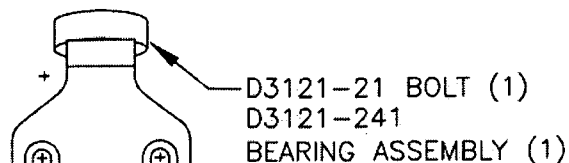
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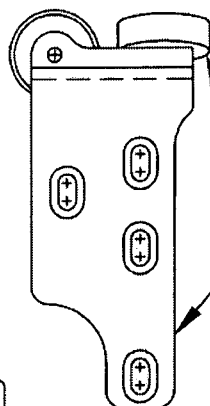
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)

D3121-111 BRACKET

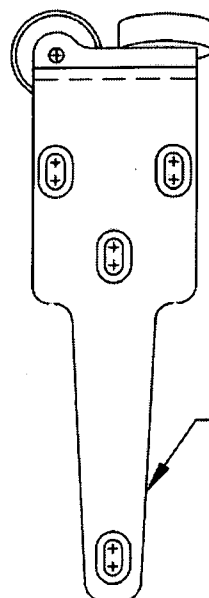
**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)



D3121-21 BOLT (1)  
D3121-241 BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)  
D3121-241 BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-115/-116  
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

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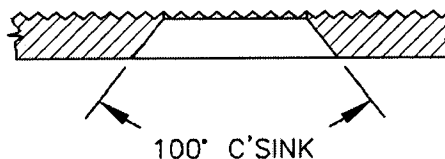
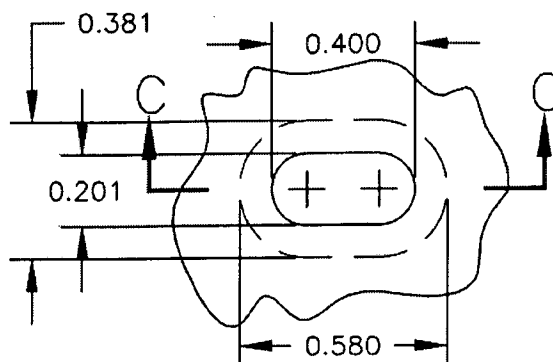
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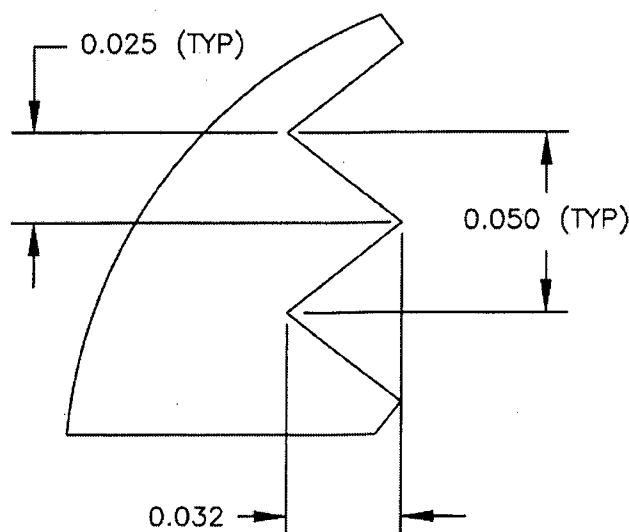
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**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**SECTION**  
**C-C**

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



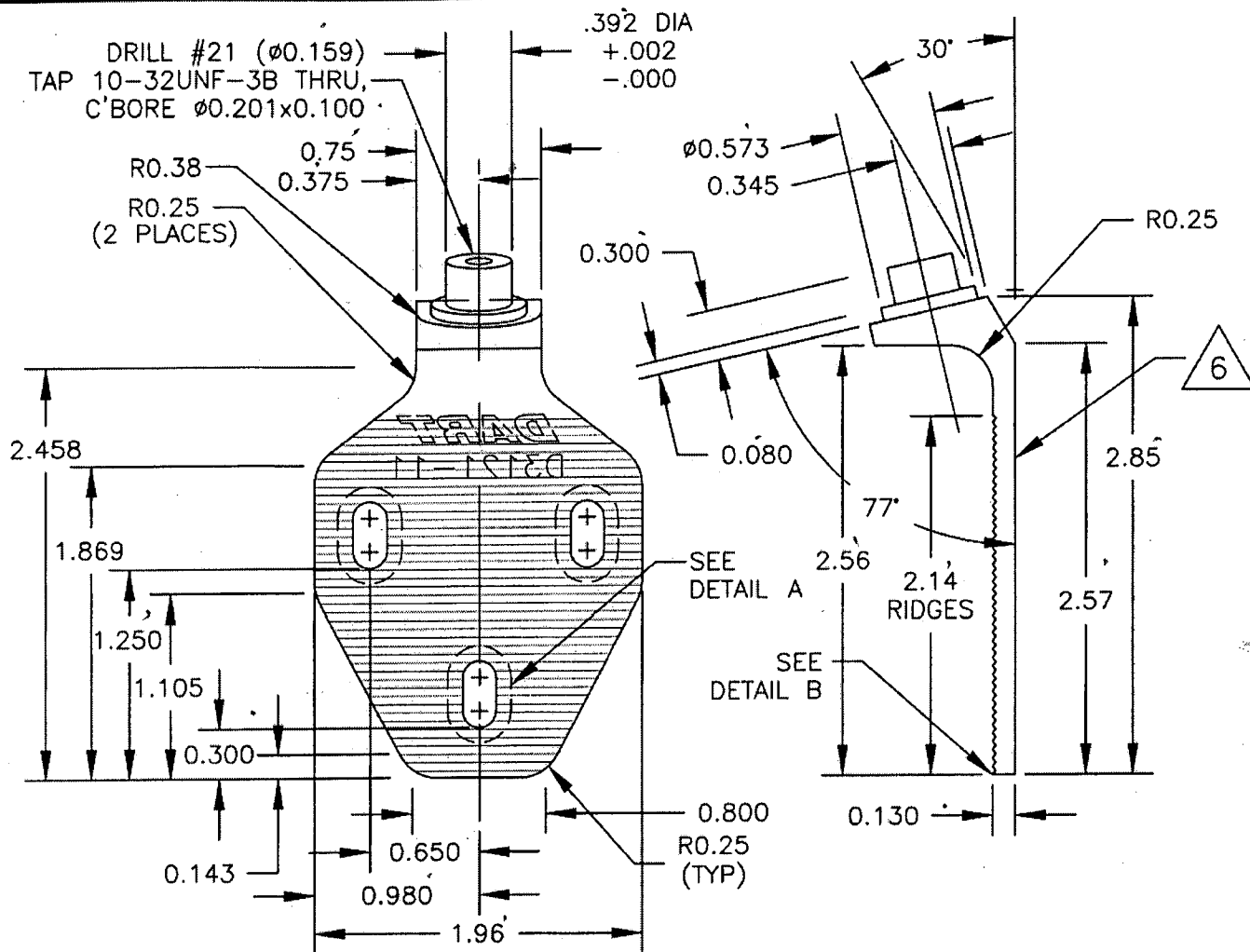
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



#### D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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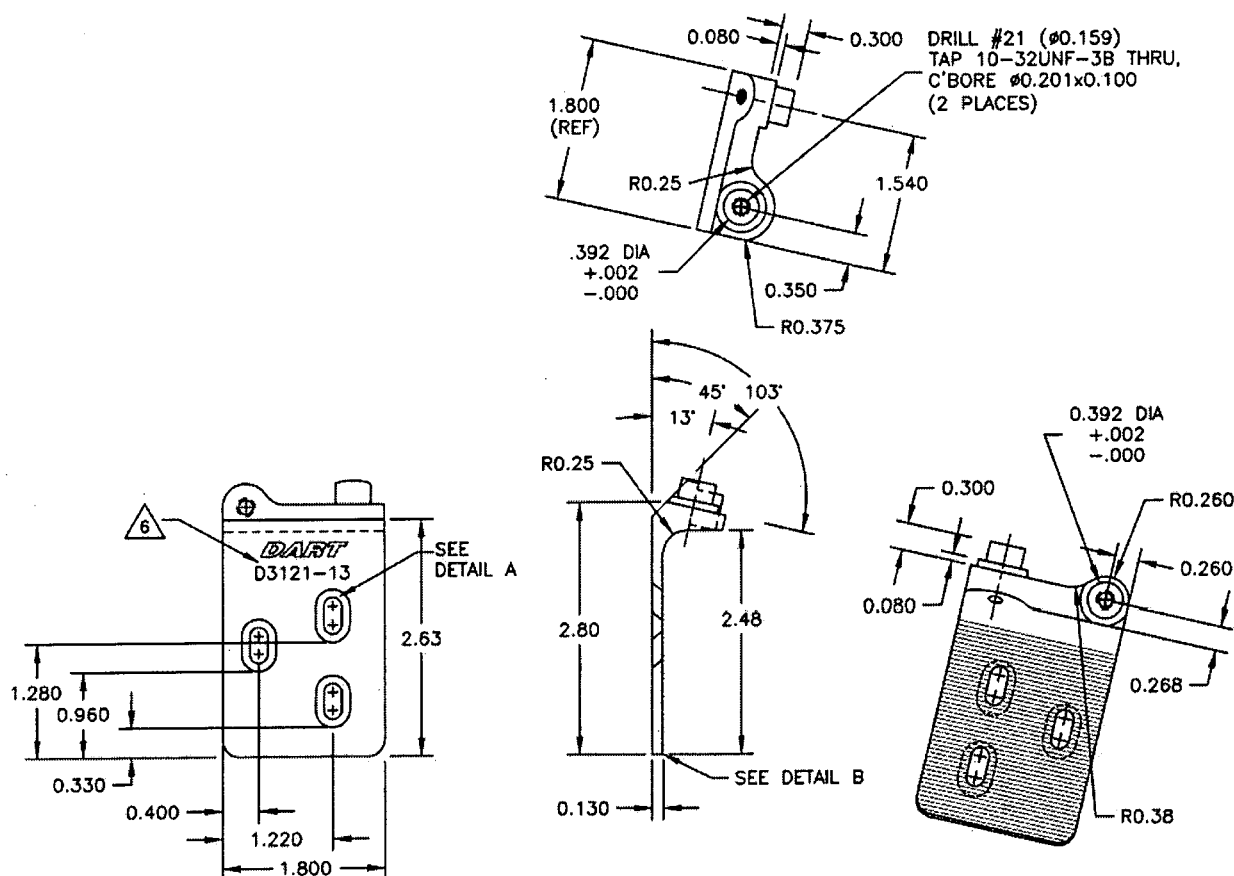
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



**D3121-13 BRACKET (SHOWN)**  
**D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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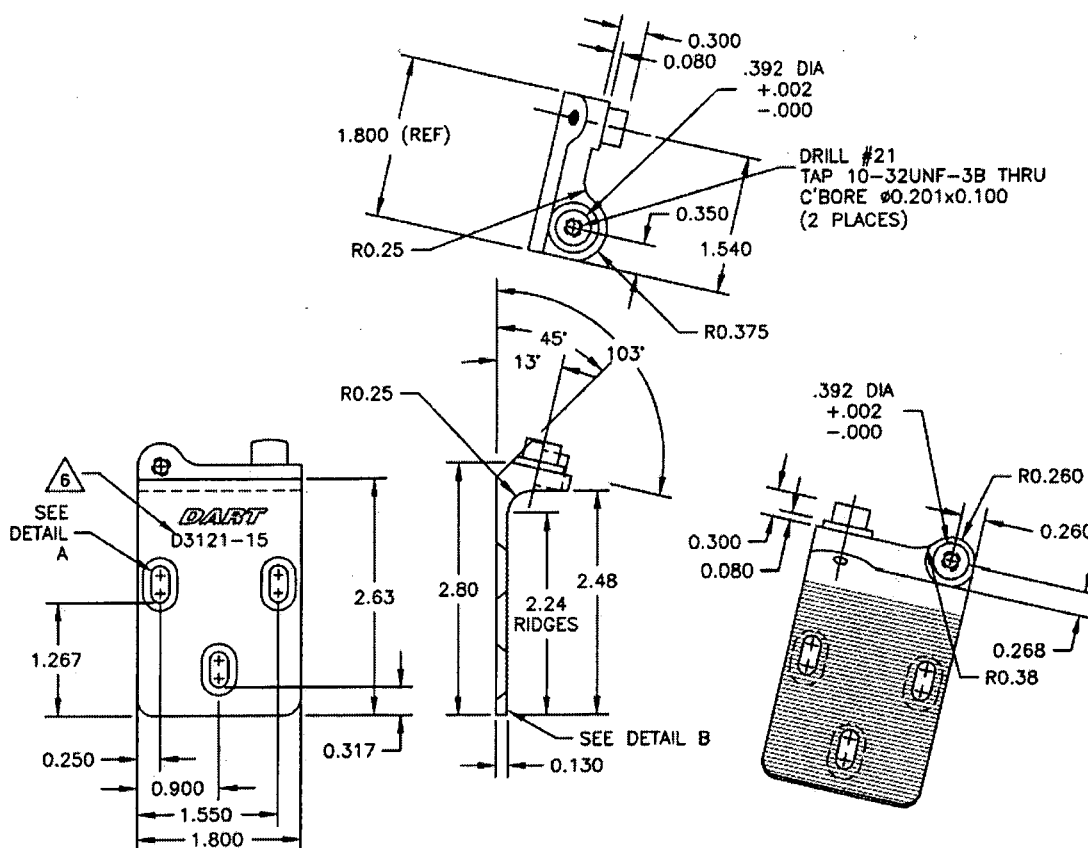
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



#### D3121-15 BRACKET (SHOWN)

#### D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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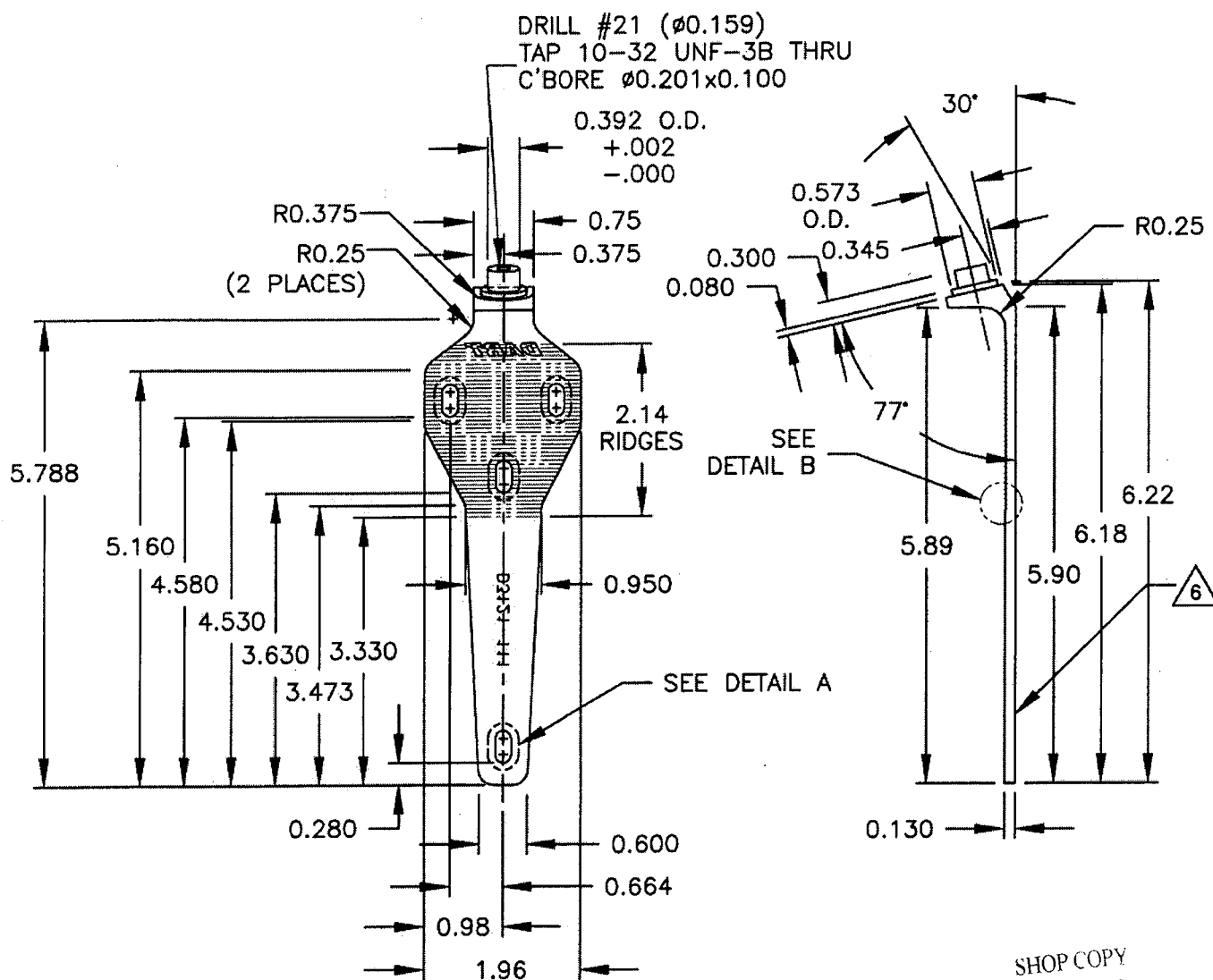
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



#### D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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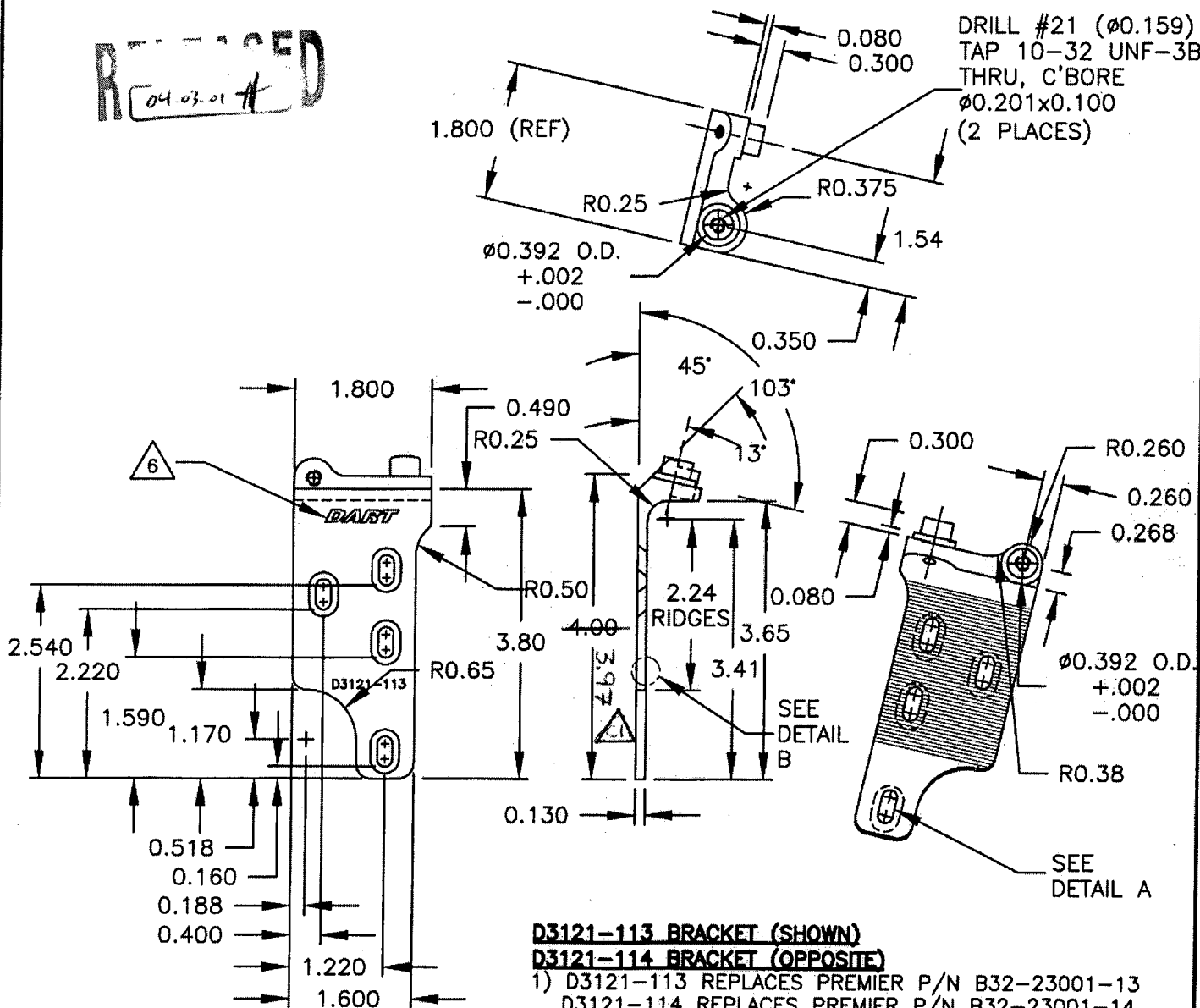
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DATE 04.02.18	TITLE BRACKET ASSEMBLY		SCALE 1:2

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**D3121-113 BRACKET (SHOWN)**

**D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES

- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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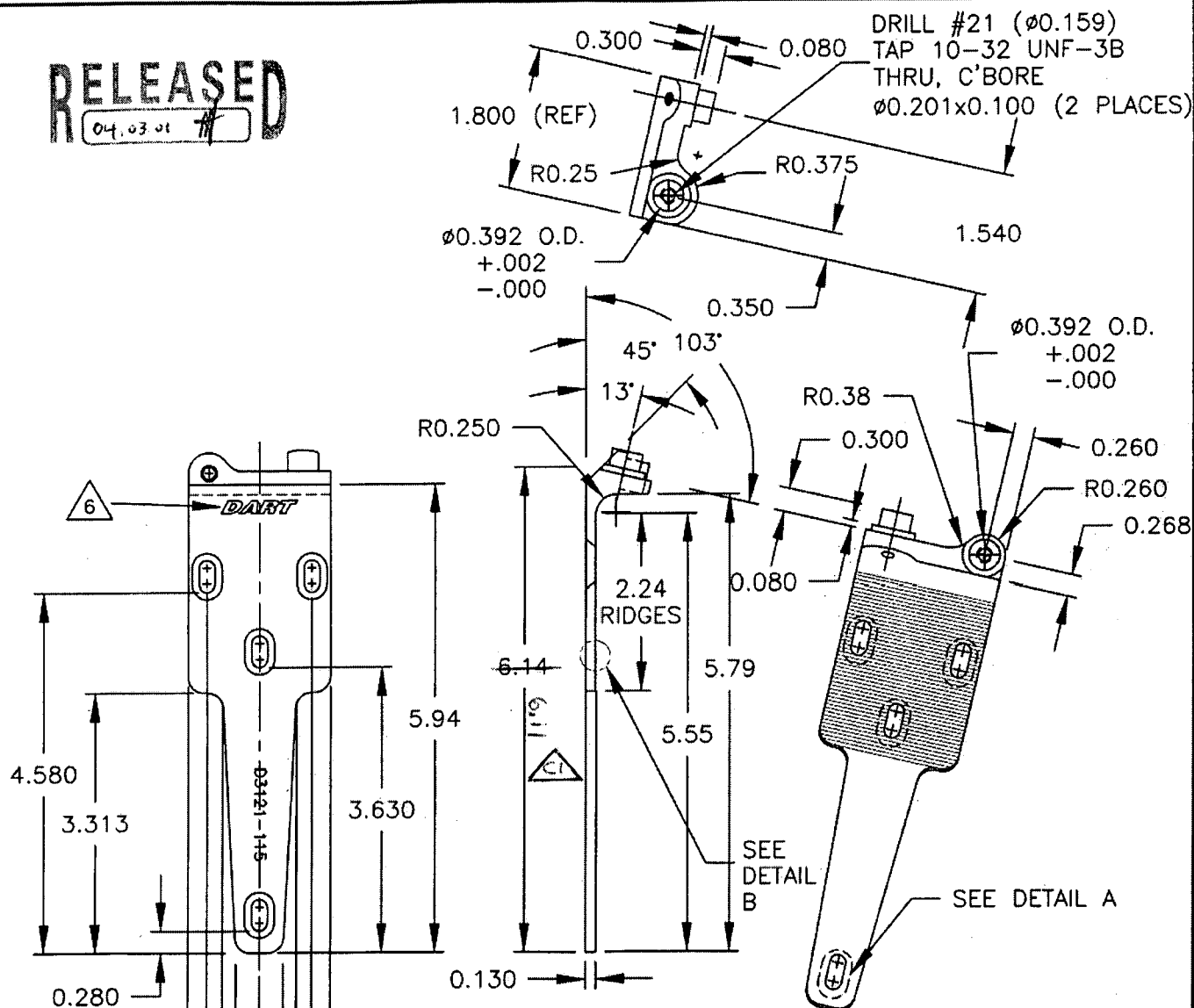
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 9 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED  
04.03.01



**D3121-115 BRACKET (SHOWN)**  
**D3121-116 BRACKET (OPPOSITE)**

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15  
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 KSI  
MIN YIELD TENSILE STRENGTH = 100 KSI
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

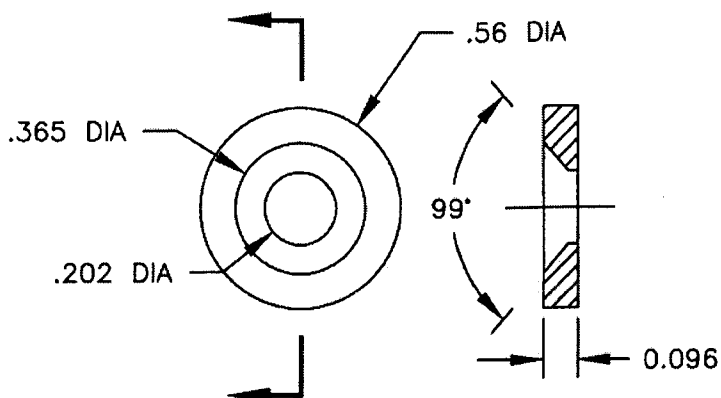
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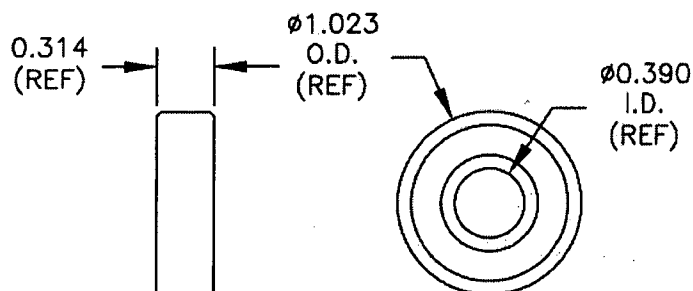


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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



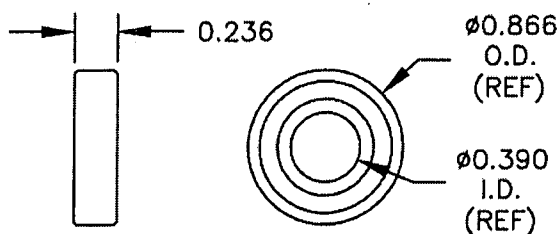
#### D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



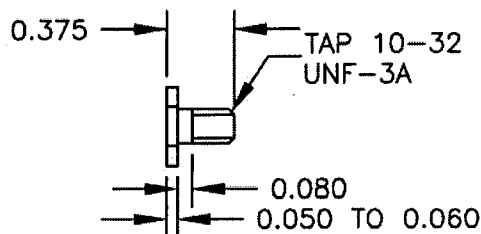
#### D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



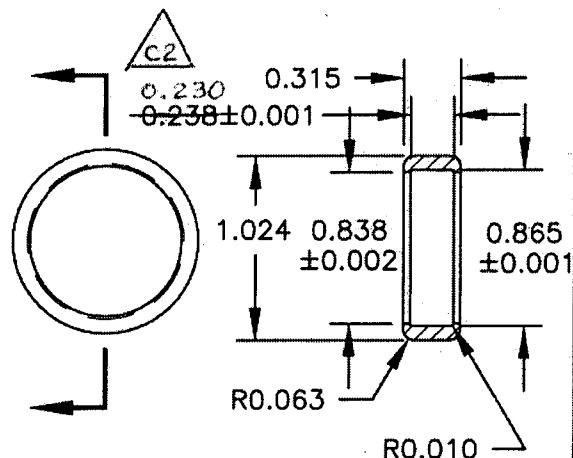
#### D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES



#### D3121-21 BOLT (SCALE 1:1)

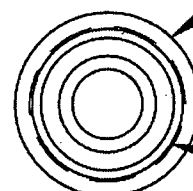
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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04.03.01 9f



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WORK ORDER  
NO. 27367  
D3121-25  
CAP  
D3121-23  
BEARING

#### D3121-241 BEARING ASSEMBLY (SCALE 1:1)

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DART AEROSPACE LTD		Work Order: 27367
Description: bracket assembly		Part Number: D3121-11
Inspection Dwg: D3121 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.392	+ .002 - .001	.392	✓			
φ201X.100	+ .010	.201X.099	✓			
.750	+ .030	.750	✓			
.375	± .010	.375	✓			
1.250	± .010	1.249	✓			
.300	"	.291	✓			
1.96	± .030	1.961	✓			
.980	± .010	.978	✓			
.650	± .010	.649	✓			
.130	"	.135	✓			
2.14	± .030	2.140	✓			
2.56	"	2.565	✓			
2.85	"	2.850	✓			
2.57	"	2.575	✓			
φ.573	± .010	.572	✓			
.300	"	.302	✓			
.080	"	.081	✓			
1.25	± .03	.25	✓			
1.380	"	.38	✓			
.800	± .010	.800	✓			

Measured by: J.L.	Audited by: MB	Prototype Approval:
Date: 06/07/12	Date: 06/07/12	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	